



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D205-541-051
Job Sheet 193745



Part No: D205-541-051

Job Qty: 1 pcs

Part Name: Bell Medium Basket Automatic Lid Opener



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/22/19

Job Tracking No:

Due Date: 5/6/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG DSI9710 REV.C IPP REV:A 15.03.26 NEW ISSUE DD VERF:JLM IPP REV:B 16.05.24 as per dsi rev.b DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs		5/6/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

DART AEROSPACE
Container No: S205461
Part: D205-541-051
Job No: 193745
Serial No/Batch: S205461
Revision:
Inspector:
Exp Date:
Instructions: TC STC SH96-120 Issue 3, FAA STC SR00696NY 07/03/27, EASA S

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					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
120 QC 4	1 pcs	5/6/19	0.00 0.00		QC 4 - 28	 8/20/2019
					QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
					QC 4 - 68	
130 Packaging 3-1 - Stock - B4B	1 pcs	5/6/19	0.00 0.00		Packaging 3 - 1 - B4B	 8/20/2019
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
135 DC - 1 - B4B	1 pcs	5/6/19	0.00 0.00		DC - 1 - B4B	DAS 21 AUG 20 2019
					DC - 2 - B4B	
140 QC 21 - FG	1 pcs	5/6/19	0.00 0.00		QC 21 - FG - 21	DAS 21 AUG 20 2019
					QC 21 - FG - 70	
					QC 21 - SA - 53	

Part Op 110 - (Pick Kit)

Descriptions: 120 - (QC4- 100% Inspect kits for completeness)

130 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP D205-541-051

135 - (Document Control) Photocopy bluefile and create labels as per PPP D205-541-051 Chg 001

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-14A	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5112900
AN3-20A	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5078752
AN310-4	Nut	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5156896
D3953-17	Gas Spring Spacer	6 pcs (6 ea)	110-Packaging 1 - Pick Kit	5106415
D3953-19	Gas Spring Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5106415
D3953-21	Gas Spring Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5106415
D3953-3	Gas Spring Stud, Lid	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	5106415
D3953-7	Spring Spacer	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	5106415
D3953-9	Gas Spring Washer	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	5106415
D3969-9	Spring (Basket Lid)	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5106415
MS21042L3	Nut	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5106415
MS24665-231	Cotter Pin	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	5106415
NAS1149F0332P	Washer	16 Ea (16 ea)	110-Packaging 1 - Pick Kit	5106415
NAS1149F0463P	Washer	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5106415

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	AN3-14A	4	237	0
	AN3-20A	4	17	0
	AN310-4	4	109	0
	D3953-17	6	11	0
	D3953-19	2	9	0
	D3953-21	2	53	0
	D3953-3	4	48	0
	D3953-7	4	54	0
	D3953-9	4	46	0
	D3969-9 -2V	2	0	0
	MS21042L3	8	3,443	0
	MS24665-231	4	113	0
	NAS1149F0332P	16	5,239	0
	NAS1149F0463P	4	509	0

Part Specifications

Specifications could not be found.

Plex 4/22/19 11:17 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-541 REV. J &
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-541 REV. 4
REF. TCCA STC SH96-120,
FAA STC SR00696NY
EASA STC EASA.IM.R.S.01242

1.0 PURPOSE:

The purpose of this DSI is to provide operators of Bell 205/210/212/214/412 Rotorcraft equipped with Dart D205-541-043/-044/-045/-046 Heli-Utility-Baskets with an Upgrade Kit to replace the existing Lid Prop Arm Assembly with an Automatic Lid Opening Gas Spring Kit. The D205-541-051 Automatic Lid Opener Kit includes parts and hardware to install a gas spring on both ends of the D205-541-043/-044/-045/-046 basket.

2.0 PARTS LIST:

ITEM No.	QTY -051	PART NUMBER	DESCRIPTION
	X	D205-541-051	AUTOMATIC LID OPENER KIT
1	4	D3953-3	GAS SPRING STUD
2	4	D3953-7	GAS SPRING SPACER
3	4	D3953-9	GAS SPRING WASHER
4	6	D3953-17	GAS SPRING SPACER
5	2	D3953-19	GAS SPRING BRACKET
6	2	D3953-21	GAS SPRING BRACKET
7	2	D3969-9	GAS SPRING
8	4	AN3-14A	BOLT
9	4	AN3-20A	BOLT
10	4	AN310-4	CASTELLATED NUT
11	8	MS21042L3	NUT
12	4	MS24665-231	COTTER PIN
13	16	NAS1149F0332P	WASHER
14	4	NAS1149F0463P	WASHER

NOTE:

For customers wishing to order new baskets with the Lid Opener pre-installed, use the following numbers:

D205-541-043 BASKET with AUTOMATIC LID OPENER installed = D205-541-043A

D205-541-044 BASKET with AUTOMATIC LID OPENER installed = D205-541-044A

D205-541-045 BASKET with AUTOMATIC LID OPENER installed = D205-541-045A

D205-541-046 BASKET with AUTOMATIC LID OPENER installed = D205-541-046A

3.0 PROCEDURE:

For D205-541-043/-044/-045/-046 Heli-Utility Baskets, replace the existing Prop Arm Assembly with gas springs on both ends of the basket. (NOTE: Once this modification is complete, it will not be possible to re-install the D2332-041 Prop Arm Assembly)

3.1 Remove the D2332-041 Prop Arm Assembly.

3.2 Grind flush and deburr the D2327-3 Spacer Bushing from the end of the basket base. Touch up paint per ICA-D205-541, Section 5.1.5.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01
APPROVED BY:  D. SHEPHERD (DE # 02)
DATE: 17.01.11
CERT. NO.: SH96-120
ISSUE NO.: 3

C	REMOVED -053, UPDATE APPLICABILITY OF -051 KIT REASON PAR17-572	SAD	17.01.11
B	FLIP GAS SPRING ORIENTATION, ADD D3969-9 ADD-053 KIT, NAS1149F0332P WASHER WAS 0363P	CP	16.05.12
A	NEW ISSUE	DB	15.02.23
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	N/A	DSI 9710	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		AUTOMATIC LID OPENER INSTL	NTS
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